

Date: Monday, 07/07/2008 11:48:08 AM  
User: Julie Lecocq

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN DOOR ROLLER KIT LH  
Job Number : 40327 *2*  
Estimate Number : 13448  
P.O. Number :  
This Issue : 07/07/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D412698031  
First Issue : 1/1 Type : SMALL / MED FAB Drawing Number : IIN D412-698 REV E  
Previous Run : Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 30/07/2008 Qty: *3* Um: Each  
Written By :  
Checked & Approved By : *JUD 08.7.07*  
Comment : Est Rev:A New Issue 08.07.03 EC verified by:LL

## Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

*JUD 08.7.08*

Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D412-698-031 CHG001

*500/0/09*

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121143 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

batch:

*39014 x2 B34664 x1 B36630 x1**JS 08/07/08 (14)*

4.0 D3137043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

batch:

*29725**JS 08/07/08 (14)*

5.0 D3183043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

batch:

*B39860**JS 08/07/08 (14)*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT LH

Job Number: 40327

Part Number: D412698031

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D32023 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Cover

batch: 40345

7.0 D3674041 BRACKET ASSEMBLY



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

BRACKET ASSEMBLY

batch: B35758 x3

8.0 D36751 SLIDING DOOR BRACKET



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

SLIDING DOOR BRACKET

batch: 40347

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-031

Location: A

PPP Rev: A

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-10-10



# **8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS** (FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

STAY COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
40327